CLAIMS

1. Method for making a vibration table (2) for concrete moulding machines of the kind used for making concrete blocks and including a bed box (22) for a vibrator consisting of side plates (10) and bed plates (12) and a top plate (4) with ribs (20), where the upwards facing side (7) of the top plate (4) includes ribs (6, 8), and where the underside (5) of the top plate (4) includes reinforcing ribs (24), and where on the underside (5) of the top plate (4) there is a mounting flange (26) for fastening the bed box (22), **characterised in that** one or more of the parts for the vibration table (2) are cast in at least one casting process, and that the vibration table (2) is built up from a combination of cast and assembled single parts, and where particularly the bed box (22) for vibrator is cast in one casting process, and where especially the top plate (4) is assembled, and where the vibration table (2) is finally formed by fastening the bed box (22) to the top plate (4).

2. Method for making a vibration table according to claim 1, **characterised in that** the assembled single parts are assembled by welding, and that the vibration table (2) is formed by the bed box (22) finally being fastened to the top plate (4) by bolts or by welding.

3. Method for making a vibration table according to claim 1, **characterised in that** the vibration table is built up by a combination of two cast and one welded individual parts, where the top plate (4) with the ribs (6, 8) are cast in a common casting process, and where the reinforcement ribs (24) and the mounting flange (26) are cast a second common casting process, and where the bed box (22) is formed by welding side plates (10), bed plates (12) and the flange (27) together, and where the vibration table is formed subsequently by a succeeding bolting/welding together of the said cast and welded parts.

4. Method for making a vibration table according to claim 1, **characterised in that** the vibration table is cast as two individual parts, as the bed box (22) for vibrator, which is constituted by side plates (10), bed plates (12) and the flange (27), are cast in a first

common casting process, and where the top plate with ribs (20), consisting of the top plate (4) with the ribs (6, 8) and reinforcing ribs (24) projecting down from the top plate (5) and the mounting flange (26) are cast in a second common casting process, and where the vibration table (2) is formed subsequently by bolting/welding together of the individual parts formed by the first common casting process and the second common casting process.

5. Method for making a vibration table according to claim 1, **characterised in that** the vibration table (2) which is constituted by a top plate (4) with a number of ribs (6, 8) and plates (10, 12) projecting down from the underside (5) of the top plate, forming a four-edged box of which two opposite sides (12) are bed plates, 4 pcs. support holders (14), disposed close to each corner of the vibration table (2) for mounting balance blocks and a balancing block (16), are cast in one and the same casting process.

6. Method for making a vibration table (2) according to claims 1 - 5, **characterised in that** wear area on the vibration table, the ribs (6, 8), are fitted with hardened wearing rails after machining.

7. Vibration table (2) for concrete moulding machines of the kind used for making concrete blocks for paving and erecting walls and including a bed box (22) for a vibrator consisting of side plates (10), bed plates (12) and flange (27), and a top plate with ribs (20), consisting of a top plate (4) the upwards facing side (7) of which includes the ribs (6, 8), and the underside (5) of which includes reinforcing ribs (24), on the sides opposite the underside (5) there is provided a mounting flange (26) for fastening a bed box (22) by a flange (27) located on it, **characterised in that** the individual parts included in the vibration table (2), such as the top plate (4), the ribs (6, 8), the side plates (10), the bed plates (12), the reinforcement ribs (24), the mounting flange (26) and the flange (27), are constituted by at least one cast element.

8. Vibration table according to claim 7, **characterised in that** this is constituted by a combination of cast and welded single parts, as the bed box (22) for vibrator, consisting of side plates (10), bed plates (12) and flange (27) for fastening the bed box (22), is constituted by at least one cast element, and where the top plate with ribs (20), con-

sisting of top plate (4) with the ribs (6, 8) and reinforcing ribs (24) projecting down from the underside (5) of the top plate and mounting flange (26), is welded, and where the vibration table (2) is formed by bolting/welding the bed box (22) and the top plate (20).

9. Vibration table according to claim 7, **characterised in that** the vibration table is built up from a combination of two cast and one welded single part(s), where the top plate (4) with the ribs (6, 8) are constituted by at least one cast first element, and where the reinforcement ribs (24) and the mounting flange (26) are constituted by at least one second cast element, and where the bed box (22) is formed by welded side plates (10), bed plates (12) and the flange (27), and where the vibration table (2) is formed by bolting/welding together of the said first and second cast elements and the welded part.

10. Vibration table according to claim 7, **characterised in that** the vibration table is constituted by at least two single elements, as the bed box (22) for vibrator, which is constituted by side plates (10), bed plates (12) and the flange (27), constitutes a first element, and where the top plate with ribs (20), consisting of the top plate (4) with the ribs (6, 8) and of the reinforcing ribs (24) projecting down from the underside (5) of the top plate, and the mounting flange (26), constitutes the second element, and where the vibration table (2) is formed subsequently by bolting/welding together of the first and the second element, respectively.

11. Vibration table according to claim 7, **characterised in that** the vibration table (2), which is constituted by a top plate (4) with a number of ribs (6, 8) and plates (10, 12) projecting down from the underside (5) of the top plate forming a four-edged box, of which two opposite sides (12) are bed plates, 4 pcs. support holders (14), disposed close to each corner of the vibration table (2) for mounting balance blocks and a balancing weight block (16), is constituted by one element.

12. Vibration table according to claims 7 - 11, **characterised in that** wear area on the vibration table, the ribs (6, 8), is provided with fitted hardened wearing rails after machining.

13. Method for making a vibration table (2) for concrete moulding machines according to claim 1, and of the kind typically used for making concrete blocks for paving and erection of walls and including a bed box (22) for a vibrator, consisting of side plates (10) and bed plates (12) and a top plate with ribs (20), consisting of a top plate (4) the upwards facing side (7) of which including ribs (6, 8), and the underside (5) of which includes reinforcing ribs (24) at the sides of which opposite the underside (5) a mounting flange (26) is fitted for fastening bed box (22) by a flange (27) situated on it, **characterised in that** the individual parts included by the vibration table (2), such as the top plate (4), ribs (6, 8), the side plates (10), the bed plates (12), the reinforcing ribs (24), the mounting flange (26) and the flange (27) are cast in at least one casting process.

14. Method for making a vibration table according to claim 1, **characterised in that** it is built up by a combination of cast and welded individual parts, as the bed box (22) for vibrator, consisting of side plates (10), bed plates (12) and a flange (27) for securing the bed box (22), is cast in a casting process, and where the top plate with ribs (20) consisting of top plate (4) with the ribs (6, 8), reinforcing ribs (24) projecting down from the underside (5) of the top plate and mounting flange (26) are welded, and where the vibration table (2) is formed by the bed box (22) finally being fastened to the top plate with bolts or by welding.